

# Work Order ID 71890

Wednesday, July 13, 2011 11:10:12 AM



Page 1

Item ID: D2055

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2055	Rev C1

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

Machine as per Folio FA203  
deburr all sharp edges as per dwg



11/10/14

12 ~~0~~

110

0.00



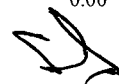
QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control



11/10/14

12 ~~0~~

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

and 11/10/14

12 ~~0~~

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71890

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Page 2

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Start Date: 7/14/2011 Start Qty: 12.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

12x Ø M-L 4/10/17

160 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:00  
OVEN TEMPERATURE: 320 °F  
FINISH TIME: 3:30

12x Ø M-L 4/10/18

170 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

12 counted 4/10/19

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 71890**

Wednesday, July 13, 2011 11:10:12 AM



Page 3

Item ID: D2055

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: STGA

0.00



Packaging

Memo

0.00

Packaging

SP 11-10-19

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19

JME  
11-10-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 13, 2011 11:10:09 AM

Page 1

Work Order ID: 71890

Parent Item: D2055

Parent Item Name: Clamp



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C 02.03.07 Now turned in house NG  
DOOSAN 10-02-01 JLM VERIFIED BY:EC IPP REV:D NOW ON

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 		Purchased	No			120	f	52.3030	0.1042	1.316211			
ROUND BAR 1.00"													

Location

Loc Qty

Loc Code

MAT013

52.303

116406

16.303

118271

36

*SD 11/10/14*

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

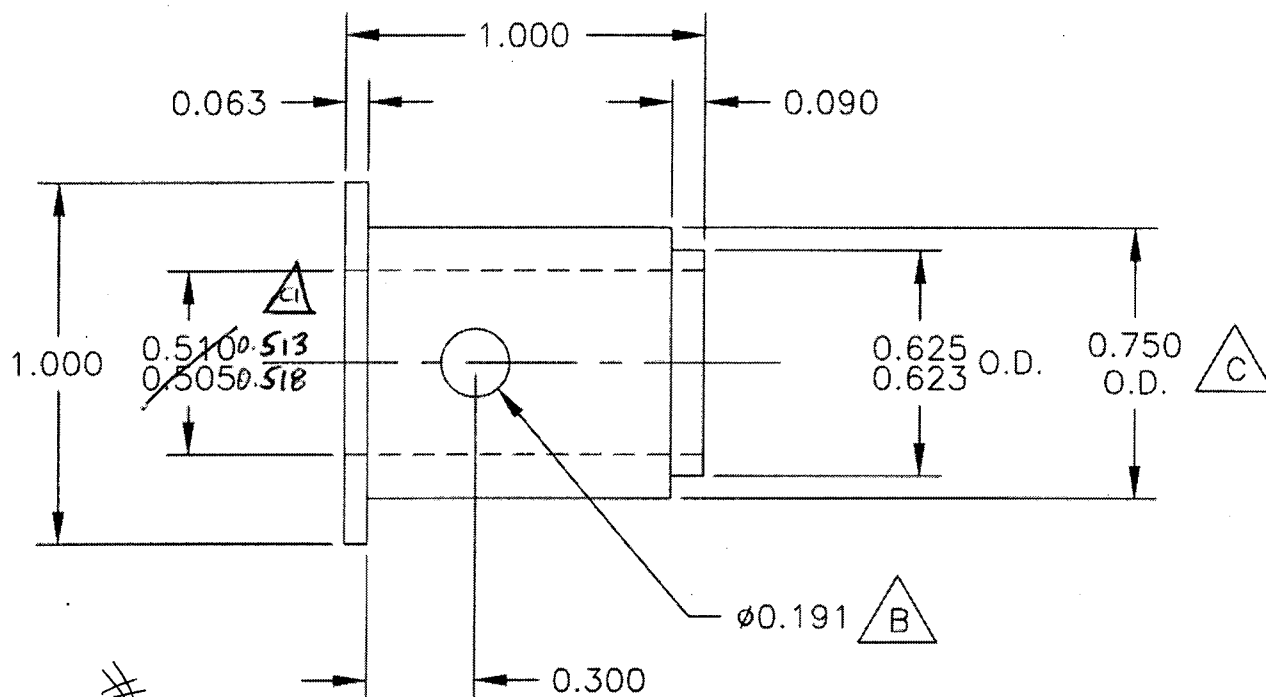
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& initial all entries



DESIGN JB	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2055	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE CLAMP	SCALE 2:1
A	92.03.13	NEW ISSUE	
B	98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH	
C	98.12.10	ADDED 0.750 O.D. DIMENSION	
CI	CP 01.06.05	MODIFY HOLE SIZE, ADD P/LC OPTION	

RELEASED  
43.12.10 KE



71890 #

**△**

ACID ETCH 4 ALODINE PER  
DART QSI D05 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7)  
PER DART QSI D05 4.3

MATERIAL: 6061-T6 ROD (QQ-A-225/8) <sup>PER DART QSI</sup>  
FINISH: BLACK ANODIZE OR —  
BREAK ALL SHARP EDGES 0.015 MAX  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

**Dart Aerospace Ltd**

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